

6061-T6 RB 0.750

Work Order ID 145330***145330***

Page 1

Thursday, May 05, 2016 1:34:08 PM

Item ID: D2022-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 5/4/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJ Date: MAY 06 2016 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2022	B

100

0.00

100

Hardinge

Memo

0.80

Hardinge CNC Lathe Small

Note: .257" dia drill
1-Turn as per folio FA206 & dwg
FOLIO REV: AA
DWG REV: B

2-Deburr as required

45

Ø

DAS

49

9-89

16/06/06

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.40

Quality Control

45

Ø

DAS

49

9-89

16/06/06

Thursday, May 05, 2016 1:34:08 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

40

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.80

Quality Control

130

Identify as per dwg & Stock Location: 5012A 0.00

0.00

130

Packaging

Memo

0.40

Packaging

45 JUN 08 2016 DAS
6
9-89

140

QC21- Final Inspection - Work Order Release	0.00
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0.00

140

QC

Memo

4.00

Quality Control

MCJ JUN 08 2016

MCS JUN 09 2016

Picklist Print

Thursday, May 05, 2016 1:34:14 PM

Page 1

Work Order ID: 145330

145330

Parent Item: D2022-101

D2022-101

Parent Item Name: Spacer

Start Date: 5/4/2016

Required Date: 5/5/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP D02.03.07 Now made in house NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	27.0465	0.03	1.2			

M6061T6R0 750

6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT012

27.0465

m131999

1.2705

m133560

2.069

m134158

8.957

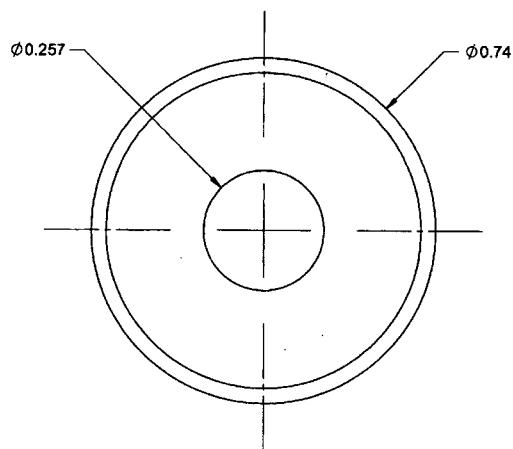
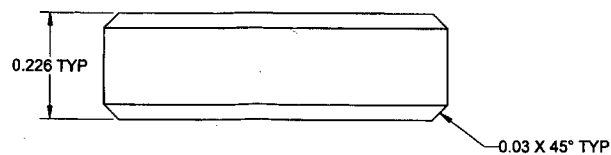
m134551

14.75

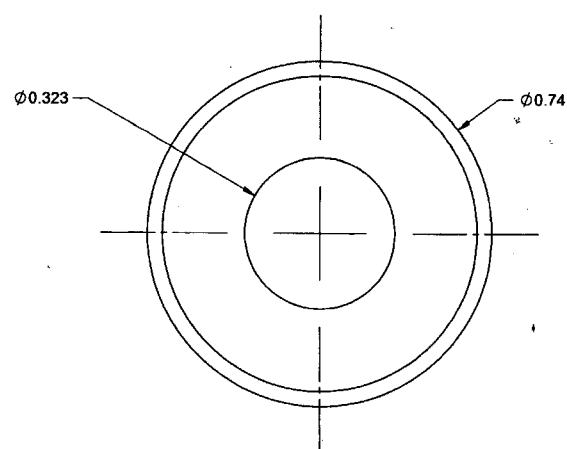
1.3

DAS
49
9-8C

16/06/06



D2022-101 SPACER



D2022-103 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
145330 MLJ
16-05-06

RELEASED
2014-08-27

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T62 ALUMINUM ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 (REF DART SPEC M6061T6R0.750)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: BAG AND TAG WITH DART P/N "D2022-101" OR "D2022-103" PER QSI 044 6.7
- 7) WEIGHT: 0.01 lbs

B	RE-FORMAT DRAWING	DB	14.03.12
A	NEW ISSUE	JB	90.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	JLM	D2022	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	SPACER	NTS
DATE	14.03.12	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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